

Work Order ID 60234

Tuesday, June 29, 2010 11:43:31 AM



Page 1

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 6/29/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: H

Date: 10/6/29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3536 | Rev A |

100 0.00



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

120 0.00



QC8- Inspect parts - second check

QC

Memo

Quality Control

8/10/2010

ml 10 07 15 (12)

ml 10 07 19 (12)

(12)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 60234

Tuesday, June 29, 2010 11:43:31 AM



Page 2

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 6/29/2010 Start Qty: 12.00



Required Date: 7/6/2010 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 Packaging Packaging | Identify as per dwg & Stock Location FPD Memo | 0.00 0.00 | | | | | | 10-7-19 | sf (130) |
| 140 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | MF 10-7-19 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 11:43:36 AM

Page 1

Work Order ID: 60234

Parent Item: D3536-23

Parent Item Name: Gasket



Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| MNEO60S.063  | | Purchased | No | | | 100 | sf | 364.8531 | 1.3365 | 16.88211 | | | |
| NEOPRENE SHEET 0.063 | | | | | | | | |  | | | | |

Location

Loc Qty

Loc Code

| | | |
|--------|----------|--|
| MAT | 259.6 | |
| 114691 | 259.6 | |
| MAT052 | 105.2531 | |
| 114176 | 105.2531 | |

ml 10 07 15

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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NOTE: Date & initial all entries

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|-----------------------|--------|--------------|----------|
| DART AEROSPACE LTD | | Work Order: | 60234 |
| Description: Gasket | | Part Number: | D3536-23 |
| Inspection Dwg: D3536 | Rev: A | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 52.85 | +/-0.030 | 52.85 | ✓ | | M.T | |
| 48.20 | +/-0.030 | 48.20 | ✓ | | M.T | |
| 44.70 | +/-0.030 | 44.70 | ✓ | | M.T | |
| 39.31 | +/-0.030 | 39.31 | ✓ | | M.T | |
| 33.92 | +/-0.030 | 33.92 | ✓ | | M.T | |
| 28.53 | +/-0.030 | 28.53 | ✓ | | M.T | |
| 23.14 | +/-0.030 | 23.14 | ✓ | | M.T | |
| 17.75 | +/-0.030 | 17.75 | ✓ | | M.T | |
| 14.25 | +/-0.030 | 14.25 | ✓ | | M.T | |
| 9.50 | +/-0.030 | 9.50 | ✓ | | M.T | |
| 4.75 | +/-0.030 | 4.75 | ✓ | | M.T | |
| 8.00 | +/-0.030 | 8.00 | ✓ | | M.T | |
| 16.00 | +/-0.030 | 16.00 | ✓ | | M.T | |
| 24.00 | +/-0.030 | 23.90 | ✓ | | M.T | |
| 32.00 | +/-0.030 | 31.90 | ✓ | | M.T | |
| 39.00 | +/-0.030 | 38.90 | ✓ | | M.T | |
| 48.00 | +/-0.030 | 47.90 | ✓ | | M.T | |
| 0.30 | +/-0.030 | 0.30 | ✓ | | Vern | |
| 0.30 | +/-0.030 | 0.30 | ✓ | | Vern | |
| 1.89 | +/-0.030 | 1.89 | ✓ | | Vern | |
| Ø0.19 | +0.005/-0.001 | 0.190 | ✓ | | Vern | |

| | |
|--------------|----------|
| Measured by: | M.M. |
| Date: | 10-07-13 |

| | |
|-------------|----------|
| Audited by: | S |
| Date: | 10/07/13 |

| | |
|---------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.03.14 | New Issue | KJ/JLM | |

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

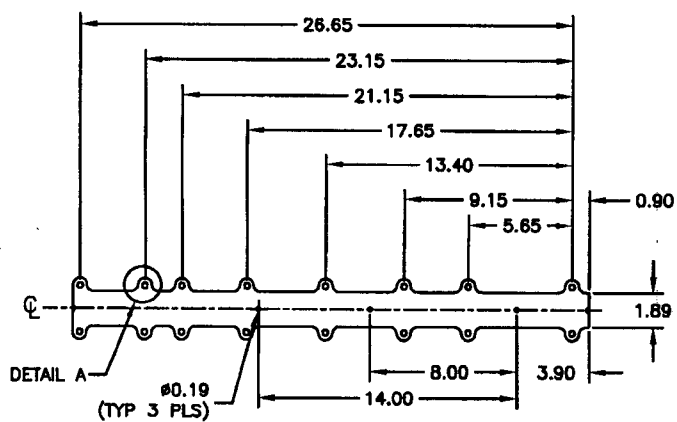
DART

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|---------|----------|-------------|--------|--------------------------|
| DESIGN | CB | DRAWN BY | CB | DART AEROSPACE USA, INC. |
| CHECKED | PH | APPROVED | PH | PORT HADLOCK, WA |
| DATE | 06.10.25 | DRAWING NO. | D3536 | REV. A |
| | | TIME | GASKET | SHEET 1 OF 6 |
| | | SCALE | 1:10 | |
| A | 06.10.25 | NEW ISSUE | | |

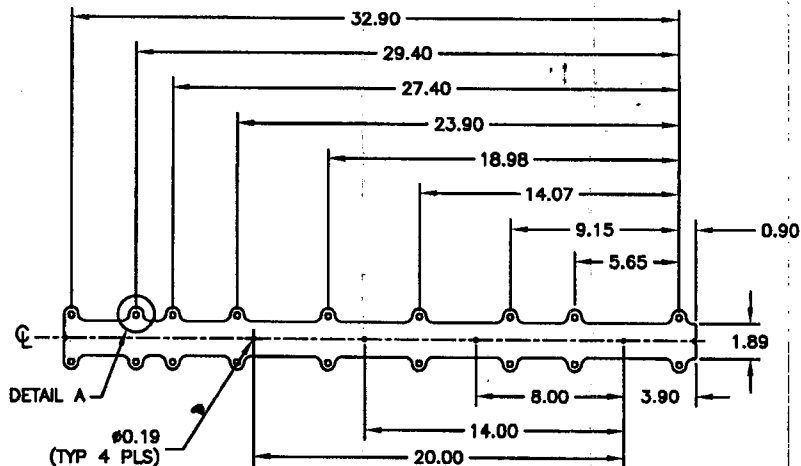
RELEASED

09-02-12-11

SHOP COPY
REFERENCE
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 00237
PS10-6-29



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

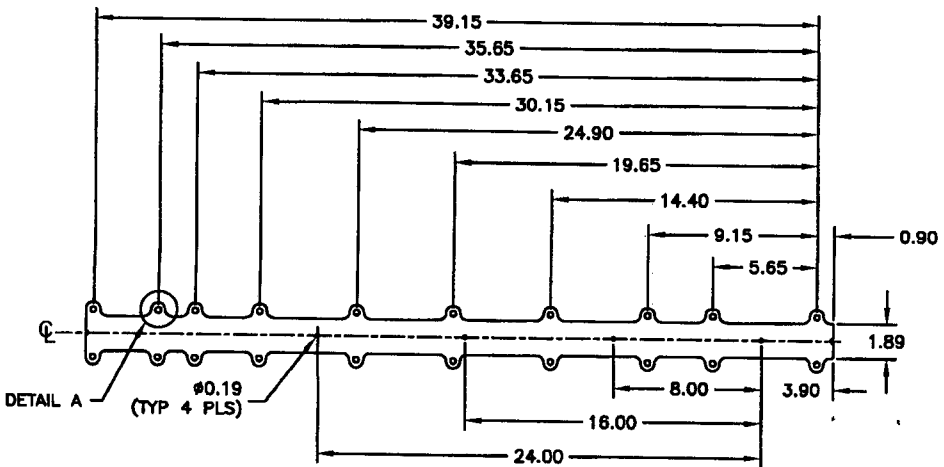
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| DESIGN | C.B. | DRAWN BY | C.B. | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED | PH | APPROVED |  | DRAWING NO. | D3536 |
| DATE | 06.10.25 | TITLE | | GASKET | SCALE |
| | | | | REV. A | SHEET 2 OF 6 |
| | | | | 1:10 | |

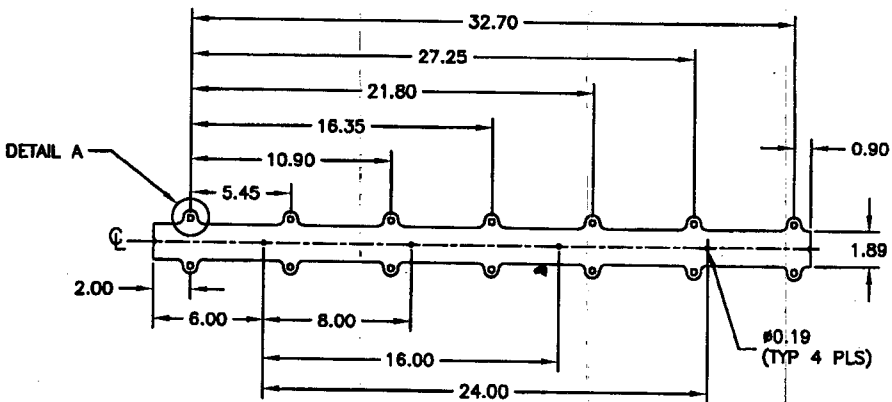
07.02.12

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rel 602341



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

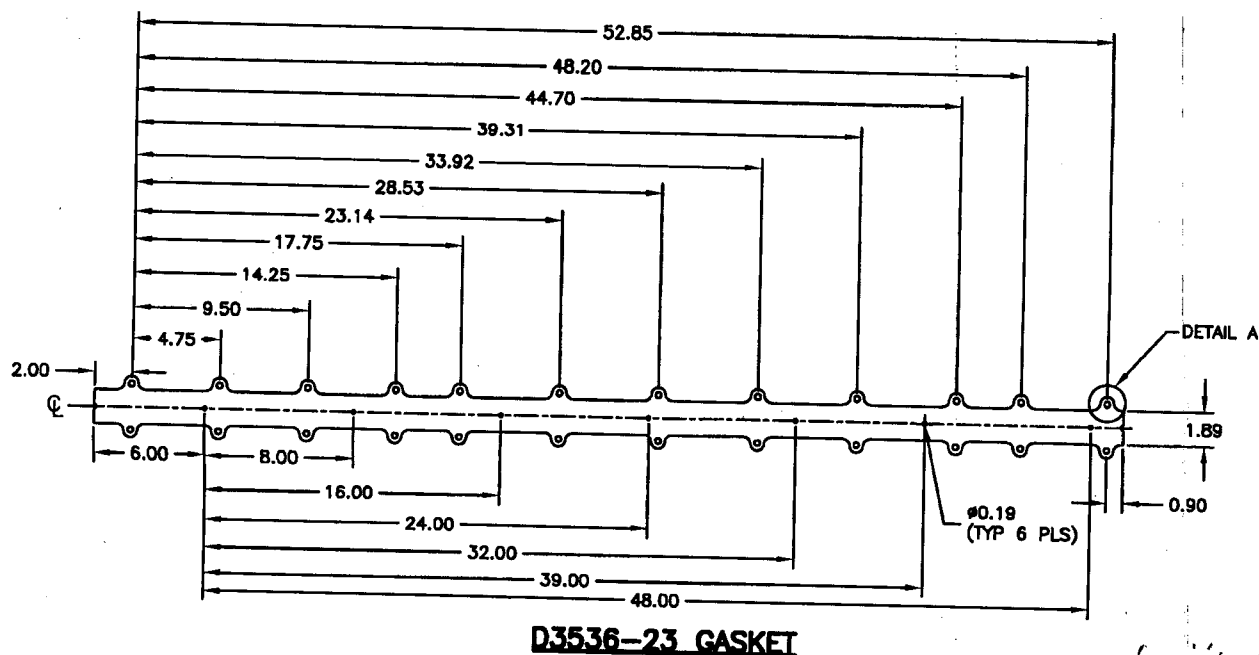
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

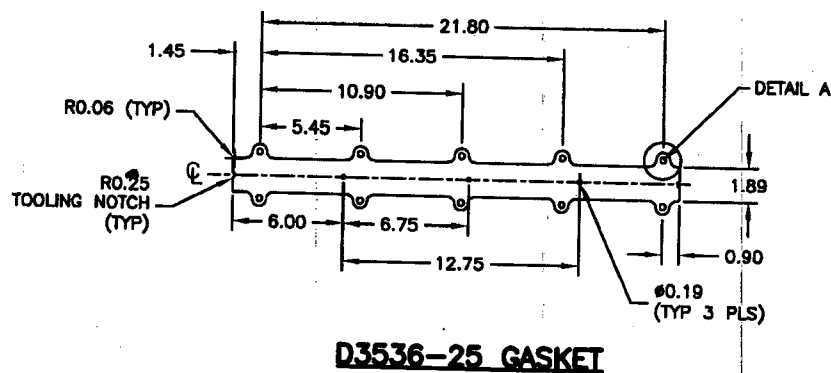
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| DESIGN | CB | DRAWN BY | CB | DART AEROSPACE USA, INC. |
| CHECKED | PH | APPROVED | PH | PORT HADLOCK, WA |
| DATE | 06.10.25 | DRAWING NO. | D3536 | REV. A |
| | | TITLE | GASKET | SHEET 3 OF 6 |
| | | SCALE | 1:10 | |

070212
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w/o 60234



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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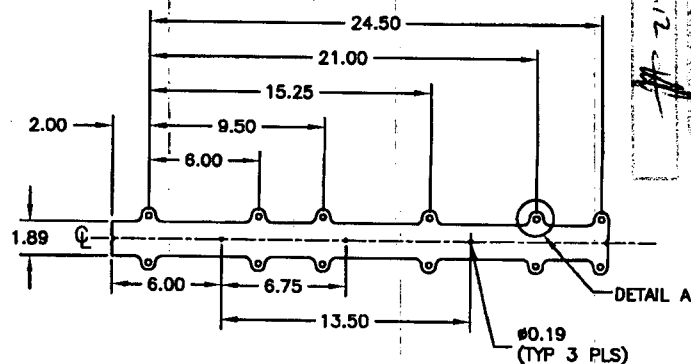
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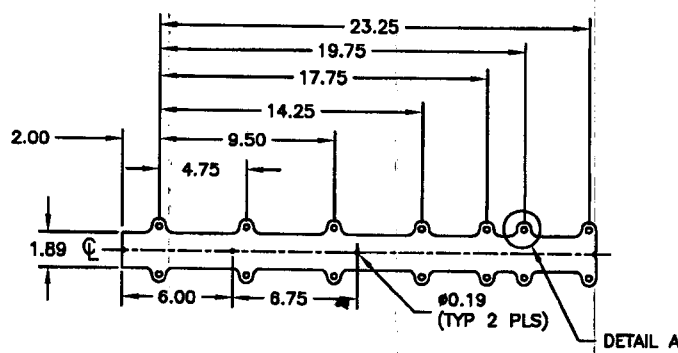
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| CHECKED | PH | APPROVED | PH | PORT HADLOCK, WA |
| DATE | 06.10.25 | TITLE | D3536 | REV. A |
| | | | GASKET | SHEET 4 OF 6 |
| | | | | SCALE 1:10 |

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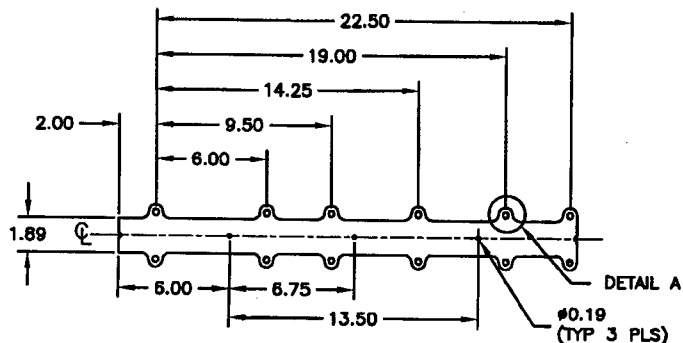


D3536-33 GASKET

w/o 66234



D3536-35 GASKET



D3536-31 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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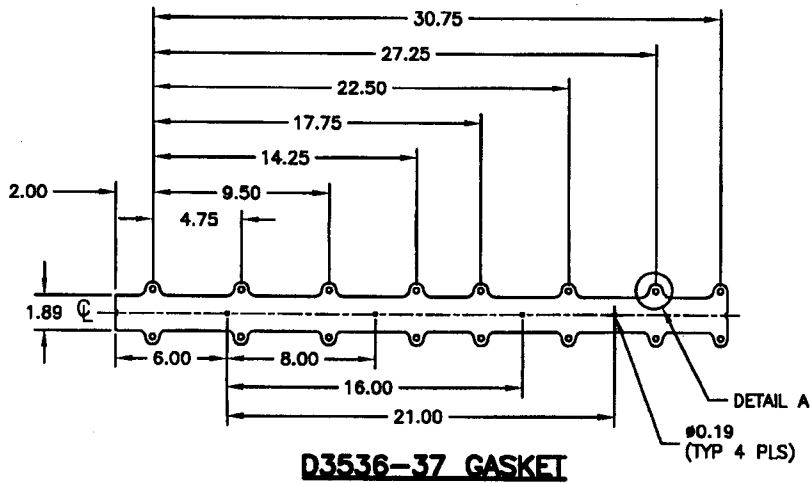
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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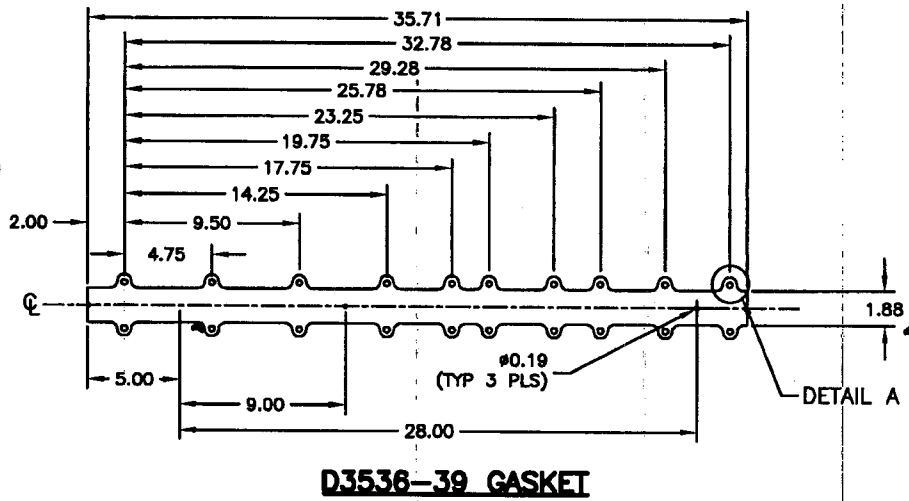
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| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | |
| CB | CB | PORT HADLOCK, WA | |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| PH | <i>[Signature]</i> | D3536 | SHEET 5 OF 6 |
| DATE | TITLE | | SCALE |
| 06.10.25 | GASKET | | 1:10 |



D3536-37 GASKET

auto 40234



D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S-063)
- 2) FINISH: NONE
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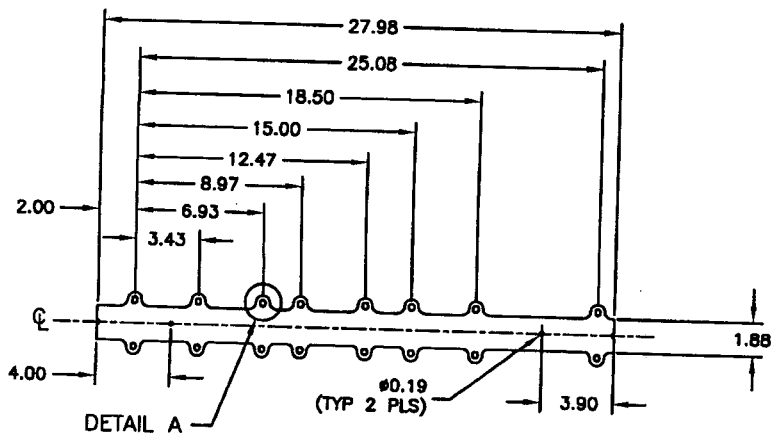
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NOTE: Date & initial all entries

DART

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | |
|------------------|---------------|--------------------------|--------------|
| CB | CB | PORT HADLOCK, WA | |
| CHECKED AH | APPROVED H | DRAWING NO. | REV. A |
| DATE 06.10.25 | | D3536 | SHEET 6 OF 6 |
| | | TITLE | SCALE |
| | | GASKET | 1:10 |

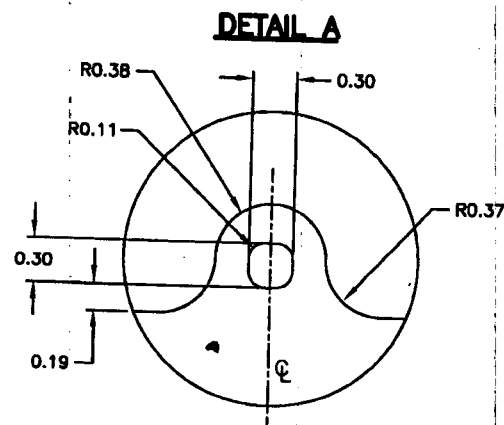
07.02.02



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries